



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.7910
Job Sheet 181420



Part No: 647.7910

Job Qty: 50 ea

Part Name: Angle Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/26/18

Job Tracking No:

Due Date: 9/10/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV N/C SHEET 2 IPP REV:A 12.10.03 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	50 Ea	9/10/18	9/10/18	0.00	0.00	Start Up Waterjet		DC 18/08/21
110	Waterjet	50 pcs	9/10/18	9/10/18	0.00	5.54	Waterjet1		DC 18/08/21
120	QC	50 pcs	9/10/18	9/10/18	0.00	0.00	QC2 Waterjet-1		DC 18/08/21
130	QC	50 pcs	9/10/18	9/10/18	0.00	0.00	QC8-1		AUG 21 2018 38
140	Brake NC	50 pcs	9/10/18	9/10/18	0.04	1.69	Brake NC 1		DAS
150	QC	50 pcs	9/10/18	9/10/18	0.00	0.00	QC5		SEP 12 2018 68
160	Outsource	50 pcs	9/10/18	9/10/18			ATG001-VC	5	SEP 18 2018 9-89
170	Packaging	50 pcs	9/10/18	9/10/18	0.00	0.00	Packaging2		OCT 10 2018
180	QC	50 pcs	9/10/18	9/10/18	0.00	0.00	QC5		NOT REQUIRED
190	SprayPaint	50 pcs	9/10/18	9/10/18	0.00	2.65	Spray Paint		DAS
200	QC	50 pcs	9/10/18	9/10/18	0.00	0.00	QC14		OCT 10 2018 68
210	Packaging	50 pcs	9/10/18	9/10/18	0.00	0.00	Packaging3-1		OCT 15 2018 6-89
220	QC21-SA	50 Ea	9/10/18	9/10/18	0.00	0.00	QC21		DAS 21 9-89

Part Op 110 - 1-Cut as per Dwg

Descriptions: 160 - ISSUE P/O: 0041004 Hard Anodize, Color Black and Prime as per Dwg. 647.7900 Rev.

190 - PRIME IAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2) CARDINAL 4860-50 PRIMER

BATCH:

210 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	4.2000 sf (.084 ea)	90-Start up Operation	306123216

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.063	4	86	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Angle Bracket	0.100Inches	+ 0.004 - 0.001	0.104 0.099	Diameter
2	Angle Bracket	0.313Inches	± 0.005	0.318	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermof ☐ Cross tube ☐ Small ☐ Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Water Jet ☐ Eng. Coord. ☐ /Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date : _____	Step #: _____	DART Aerospace Ltd. 1270 Aberdeen Street Haverhill, MA 01830 CANADA Tel.: 1 813 632-6200 Email: sales@dartaero.com www.dartaerospace.com Date: 08/21/18																																																											
Description																																																													
Root Cause <table border="1" style="width:100%; border-collapse: collapse;"> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table> <table border="1" style="width:100%; border-collapse: collapse;"> <tr><td>Crimp/Kink/Ripple/Wave</td><td>☐</td></tr> <tr><td>Cuffs</td><td>☐</td></tr> <tr><td>Crushing</td><td>☐</td></tr> <tr><td>Heat Treat</td><td>☐</td></tr> <tr><td>Wave/Twist in Tube</td><td>☐</td></tr> <tr><td>Marks/Chatter</td><td>☐</td></tr> </table>				Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	Crimp/Kink/Ripple/Wave	☐	Cuffs	☐	Crushing	☐	Heat Treat	☐	Wave/Twist in Tube	☐
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			0.308
3	Angle Bracket	1.313Inches $\pm$ 0.005	1.318 1.308
4	Angle Bracket	2.313Inches $\pm$ 0.005	2.318 2.308
5	Angle Bracket	3.313Inches $\pm$ 0.005	3.318 3.308
6	Angle Bracket	3.625Inches $\pm$ 0.005	3.630 3.620
7	Angle Bracket	0.625Inches $\pm$ 0.005	0.630 0.620
8	Angle Bracket	3.325Inches $\pm$ 0.005	3.330 3.320

Plex 7/26/18 8:33 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041004**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

PO No: PO041004
PO Date: 9/12/18
Due Date: 10/12/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Attention: Lalande, Marc-Andre

Via: Ground
Pymt Terms: Net 30

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	181371	647.7917	Bracket ISSUE P/O: _____ 1- HARD ANODIZE, COLOR BLACK AS PER DWG. 2- PRIME IAW MIL-P- 23377J TYPE1 CLASS N AS PER DWG. CARDINAL 4860-50 PRIMER. AS PER DWG. 647.7900 "NOTE 2" Certification of Conformity is required	Firmed	-	10/12/18	35 pcs	0 pcs	35 pcs	\$12.30/pcs	\$430.50
2	181420	647.7910	Angle Bracket ISSUE P/O: _____ 1- HARD ANODIZE, COLOR BLACK AS PER DWG. 2- PRIME IAW MIL-P- 23377J TYPE1 CLASS N AS PER DWG. CARDINAL 4860-50 PRIMER. AS PER DWG. 647.7900 "NOTE 2" Certification of Conformity is required	Firmed	-	10/12/18	52 pcs	0 pcs	52 pcs	\$9.40/pcs	\$488.80



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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PURCHASE ORDER **PO041004**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3		644.4110	Aft Bracket, Large 1-ISSUE P/O TO ATG: _____ 2- Hard Anodize IAW Mil-A-8625 Type 3 Class 2, Color Black. 3-Pretreat PR-148 Adhesion Promoter. 4-Prime with Desoto 515X349 IAW BMS 10-79 Type 3 Class A Grade A. AS PER DWG. 644.4100 "NOTE 4" Certification of Conformity is required 181916	Firmed	-	10/12/18	20 pcs	0 pcs	20 pcs	\$8.45/pcs	\$169.00
Grand Total:											\$1,088.30

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

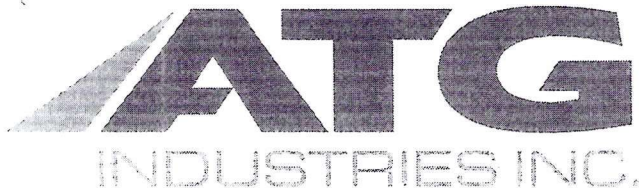
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/21/18 2:36 PM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916195

Date: 09-Oct-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
35 ea	Part: 647.7917 Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 23775	Rev: NC PO: PO041004	Line: 1
49 ea	Part: 647.7910 Angle Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 23776	Rev: NC PO: PO041004	Line: 2
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>09/10/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			

Reply all | ▾ Delete Junk | ▾ ...

RE: PO041004 Part # 647-7910 QTY 52

RA

Robert Aboud

Today, 4:00 PM

Natasha Belanger ▾



Reply all | ▾

Inbox

You replied on 10/9/2018 4:09 PM.

They claim they only received 49 pcs

Rob Aboud

*Director of Supply Chain***DART AEROSPACE**

T 1-613-632-5200 Ext.244

M 1-514-979-6138

www.dartaerospace.com

From: Natasha Belanger**Sent:** Tuesday, October 09, 2018 3:35 PM**To:** Robert Aboud <raboud@dartaero.com>**Subject:** PO041004 Part # 647-7910 QTY 52

Good Afternoon,

Please find attached copies.

I would like to receive the above PO, before doing so, I will need confirmation of quantity. According to the job & PO we sent out 52 pieces, ATG sent back 49.

Can we ask ATG what happened to the other 3 pieces?

Thank you,

Natasha Bélanger*Receiver***DART AEROSPACE**

T 1 613 632-5200 > 248

F 1 613 632-5246

1 800 556- 4166

www.dartaerospace.com